

Work Order ID 82527

April-02-12 3:08:39 PM

82527

Ship May 11th

Page 1

Item ID: D4030-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Long Basket Assembly, Light Lid (350)

Stop ***NS2***

Start Date: 02/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/02* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4030

C

100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

1

12/05/01 JB

110 Assemble as per dwg

0.00

110

HandFinish

Memo

0.00

Hand Finishing

1

φ

BL 12-54

120 QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

Snider

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Long Basket Assembly, Light Lid (350)

Stop ***NS2***Start Date: 02/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

PPP 82527

12/5/04

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/05/04

MCJ 12/05/04

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P & NAS1149C0432R 10.06.16 DD
VERF:EC IPP Rev:D as per
dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	4.0000	1	1	✓		
<div> <div>**</div> <div>82895 JB</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		4							
				77030		1							
				78965		3							
D2535 *D2535* Spring		Manufactured	No			100	Each	34.0000	2	2	✓		
<div> <div>**</div> <div>1x 83545 JA</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		34							
				77488		34							
D2537 *D2537* Bushing		Manufactured	No			100	Each	24.0000	2	2	✓		
<div> <div>**</div> <div>82896 JB 12/05/01</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		24							
				77055		24							
D3913-041 *D3913-041* Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
<div> <div>**</div> <div>1 BR 12-5-4</div> </div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		24							
				77055		24							

82527

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3915-041

Manufactured No

100

Each

0.0000

1

1

D3915-041

Light Lid Assembly, Long Basket

D3917-3

Manufactured No

100

Each

97.0000

6

6

D3917-3

Washer

82531

**

1

BL 125-4.

**

JB

Location

Loc Qty

Loc Code

ST070

97

76956

4

80598

1

81205

92

81205

D3953-3

Manufactured No

100

Each

34.0000

2

2

D3953-3

Gas Spring Stud, Lid

**

JB

Location

Loc Qty

Loc Code

ST075

34

78042

18

82044

16

2x 82044

D3953-7

Manufactured No

100

Each

44.0000

2

2

D3953-7

Spring Spacer

**

JB

12/05/01

Location

Loc Qty

Loc Code

ST075

44

76295

4

82045

40

82045

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 60.0000 2 2 ✓

D3953-9

Gas Spring Washer

**

JB

Location

Loc Qty

Loc Code

ST075 60
78916 8
82035 52

82035

2 ✓

D3953-17 Manufactured No

100 Each 35.0000 2

D3953-17

Gas Spring Spacer

**

JB

Location

Loc Qty

Loc Code

ST075 35
81206 24
81454 11

81206

1 ✓

D3953-19 Manufactured No

100 Each 10.0000 1

D3953-19

Gas Spring Bracket

**

82938 JB

Location

Loc Qty

Loc Code

ST075 10
75227 10

1 ✓

D3953-21 Manufactured No

100 Each 27.0000 1

D3953-21

Gas Spring Bracket

**

JB

12/05/01

Location

Loc Qty

Loc Code

ST075 27
81207 21
81456 6

81207

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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82527

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 30.0000 1 1 ✓

D3969-3

Spring (Basket Lid)

**

JB

Location

Loc Qty

Loc Code

ST272

30

64285

1

73515

9

81887

20

81887

AN3-14A Purchased No

100 Each 80.0000 4 4 ✓

AN3-14A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST352

80

119328

80

119328

AN3-20A Purchased No

100 Each 126.0000 2 2 ✓

AN3-20A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST352

126

115371

26

117441

100

115371

AN4-12 Purchased No

100 Each 77.0000 3 3 ✓

AN4-12

Bolt

**

JB 12/05/01

Location

Loc Qty

Loc Code

ST357

77

118626

2

119775

25

120986

50

120986

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82527

82527

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

160.0000

2

2

✓

AN5-17A

Bolt

**

JB

Location

Loc Qty

Loc Code

338

100

121181

100

121181

ST338

60

117872

42

120498

18

AN5-21A

Purchased

No

100

Each

32.0000

2

2

✓

AN5-21A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST338

32

114714

32

114714

AN310-4

Purchased

No

100

Each

88.0000

3

3

✓

AN310-4

NUT

**

121441

JB

12/05/01

Location

Loc Qty

Loc Code

ST344

88

120124

13

120518

25

121011

25

121162

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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82527

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

82.0000

2

2

✓

AN310C4

Nut

**

JB

Location

Loc Qty

Loc Code

ST344

82

119324

2

120360

30

121166

50

121166

MS21042L3

Purchased

No

100

Each

2,541.000

6

6

✓

MS21042L3

Nut

**

121349 *JB*

Location

Loc Qty

Loc Code

ST300

2541

117441

16

117885

32

118451

5

118927

3

119017

2219

119075

166

121162

100

MS21042L5

Purchased

No

100

Each

1,517.000

4

4

✓

MS21042L5

Nut

**

JB 12/05/01

Location

Loc Qty

Loc Code

ST300

1517

116105

5

116548

43

117611

42

119109

1427

119109

April-02-12 3:08:44 PM

Shop Packet Print

Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 7

Work Order ID: 82527

82527

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

296.0000

3

3

✓

MS24665-151

Cotter Pin

**

JB

Location

Loc Qty

Loc Code

ST309

296

17566

296

17566

MS24665-300

Purchased

No

100

Each

201.0000

2

2

✓

MS24665-300

Cotter Pin

**

JB

Location

Loc Qty

Loc Code

GA

197

118234

197

118234

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

240.0000

6

6

✓

NAS1149F0432P

Washer

**

121415 *JB*

Location

Loc Qty

Loc Code

ST275

240

121060

40

121166

200

NAS1149F0563P

Purchased

No

100

Each

77.0000

4

4

✓

NAS1149F0563P

Washer

**

JB 12/05/01

Location

Loc Qty

Loc Code

ST275

77

117735

77

117735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82527

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Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

590.0000

8

8

✓

NAS1149F0332P

JB

WASHER

Location

Loc Qty

Loc Code

ST275

590

117735

37

119225

10

120910

200

120986

200

121166

140

17317

3

120910

NAS1149C0432R

Purchased

No

100

Each

2,278.000

2

2

✓

NAS1149C0432R

JB

12/05/01

Washer

Location

Loc Qty

Loc Code

ST297

2278

117291

1278

119124

1000

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

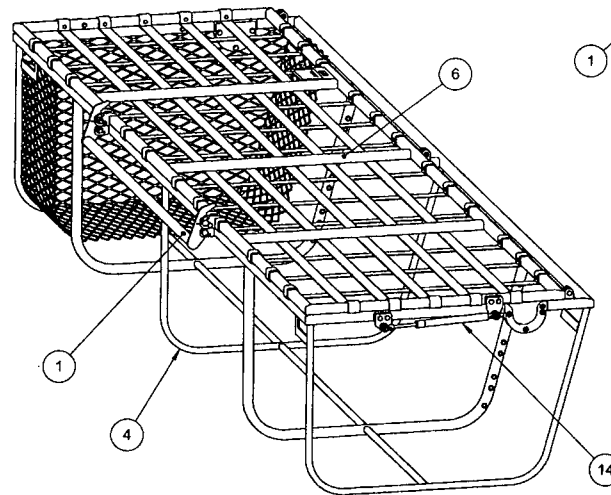
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

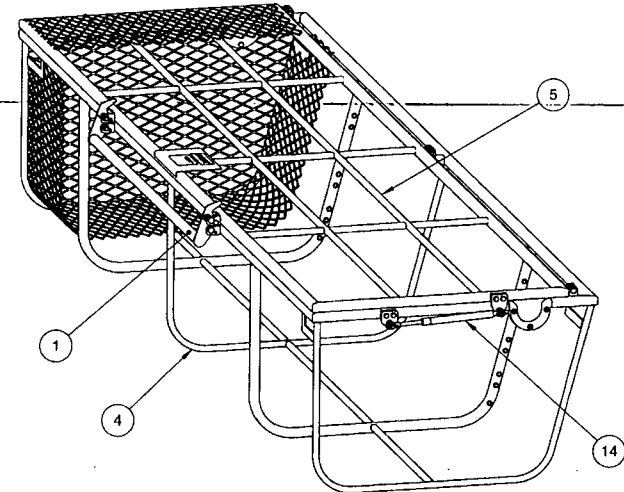
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82527465

12/04/02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.08.12.04
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JP		
CHECKED	JFS		
MFG. APPR.	JFS		
APPROVED	JFS		
DE APPR.	JFS		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. C
SHEET 1 OF 3

TITLE **LONG BASKET ASSY (350)** SCALE NTS

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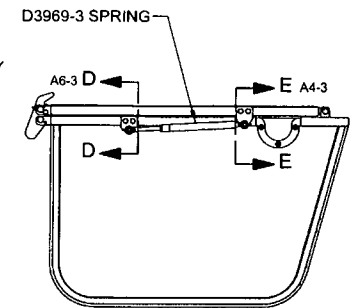
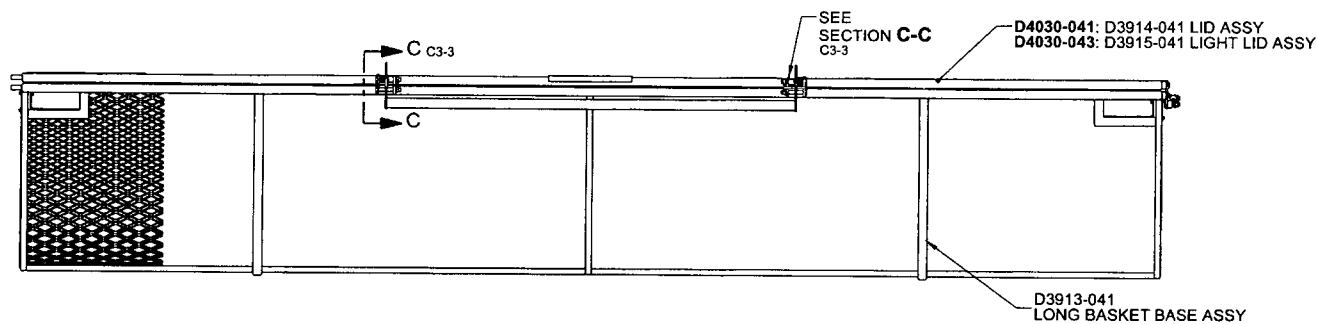
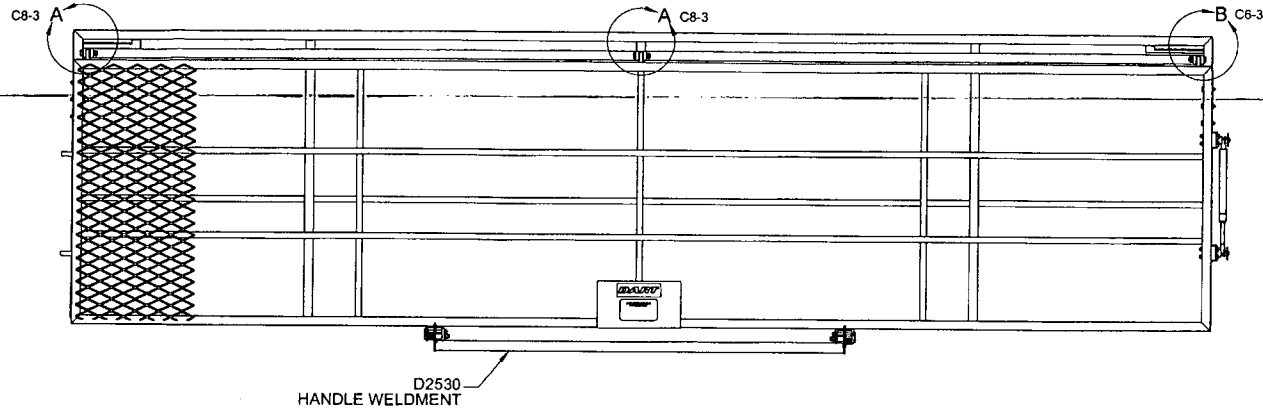
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17.00

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SFS	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

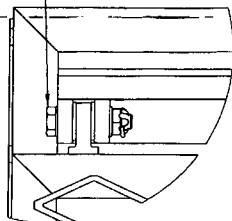
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

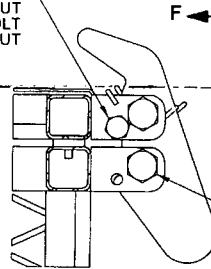
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



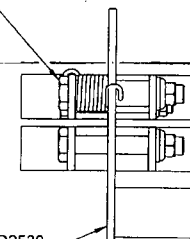
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries